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PROGRESS REPORT

FOR

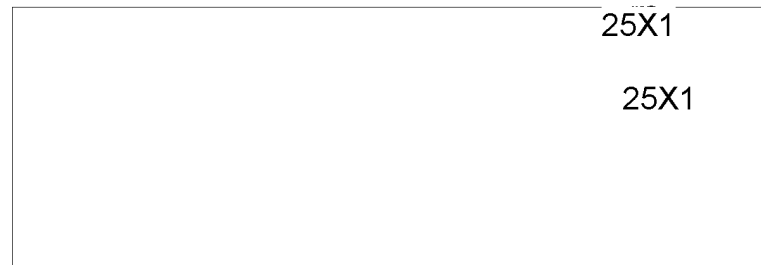
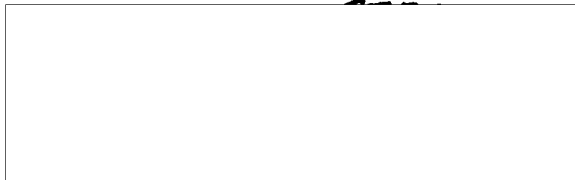
SEPTEMBER 1959

ON THE

CLAM PRODUCTION

RD 45, TASK ORDER S

10 Progress reports
Oct '58 - Sept '59
Clam Production



25X1

25X1

26 October 1959

CONFIDENTIAL

The completed lot of 3000 Clams was shipped during the month as per the instruction received.

FINANCIAL STATEMENT

Total Amount of Contract	\$ 14,918.00
Expenditures for September 1959	none
Total Expenditures to 30 September 1959	14,690.22
Balance of Contract	317.78

Expiration Date: 2 October 1959



25X1

PROGRESS REPORT

FOR

AUGUST 1959

ON THE

CLAM PRODUCTION

RD 45, TASK ORDER S

Rec'd ED 1200
10/7/59
mk

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See 9a

file: Explosive clam
MK II

28 September 1959

The reworking of the Clams was completed during August and the inspection of the three thousand units was undertaken. The inspection was performed using the newly written specifications, and it was determined that the Clams were fully acceptable.

As a result of the inspection, it was decided that the mold should be modified slightly for future production of units and also given a thorough inspection before storage or additional production. The change consisted of extending by $1/32$ ", the neck or eyelet at the base of each magnet cavity. This was felt to be desirable since a small flange at the bottom of the coated magnet (where the spring attaches) presented a slightly weak area. Bids are to be secured for this modification to the mold as well as for the inspection to determine if it has suffered any damage during the past production.

Following receipt of a mailing address, the lot of Clams will be shipped.

FINANCIAL STATEMENT

Total Amount of Contract	\$ 13,445.00
Extension of Funds Applied for 11 August	1,473.00
Total	14,918.00
Expenditures for August 1959	271.71
Total Expenditures to 31 August 1959	14,690.22
Balance of Contract	317.78

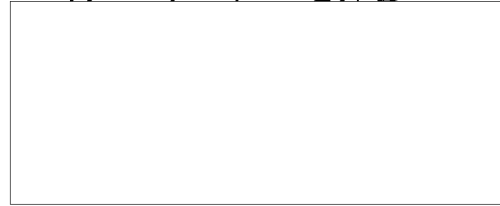
Expiration Date: 2 September 1959

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9/10/59 mcl



*file Explosive Clam
MKII*

PROGRESS REPORT

FOR

JULY 1959

ON THE

CLAM PRODUCTION

RD 45, TASK ORDER S

1 September 1959

Reworking of the Clams was started during July following approval by the Project Officer of the new sealing technique.

This technique involved wrapping aluminum foil around the end of the Clam to be resealed. The Clam was placed in a holder and the sealing iron was brought in contact with a with a slight downward pressure. The iron, set at a temperature of about 1000°F, was held for one minute and removed. When cool, the aluminum foil was removed and excessive flashing removed by trimming. One Clam sample from every ten was water tested at 30 lbs. line pressure, and one sample from every one hundred Clams was dissected to inspect the thickness of the seal.

It is expected that the lot will be reworked completely by early August and will then be ready for inspection.

FINANCIAL STATEMENT

Total Amount of Contract	\$ 13,445.00
Extension of Funds Applied For 11 August	1,473.00
Total	14,918.00
Expenditures for July 1959	1,033.48
Total Expenditures to 31 July 1959	14,418.51 <i>11 C</i>

Expiration Date: Extension Requested from
2 July 1959 to 2 Sept. 1959

Explosive,
Clam

PROGRESS REPORT
FOR
JUNE 1959
ON THE
CLAM PRODUCTION
RD 45, TASK ORDER S

28 July 1959

Several experiments were made during the month of June pertaining to the sealing of the insert in the box.

One of the first methods tried was to attach a copper block to the soldering iron used for sealing. This block had fittings at either side which were connected to a source of cold water. After sealing for a certain period of time, water was passed through the block thereby cooling it and permitting its easy removal from the polyethylene. This made a good seal but was very time consuming due to slow recovery time of the iron.

Two samples were sealed by the above method and two samples were sealed by the original method which consisted of wiping a hot soldering iron across the insert and box with a drop of silicon oil on the iron as a mold release. One of each of the above clams was tested with pencils and detonator to find out if the item functioned and whether the insert remained in place or not. The original method functioned but the insert was blown out. The water cooled seal also functioned but the insert remained in place and the seal was unbroken.

Several clams were then sealed using different temperatures and also allowing the copper block attached to the iron to remain in contact with the surface for varying periods. Small pieces of aluminum foil were wrapped around

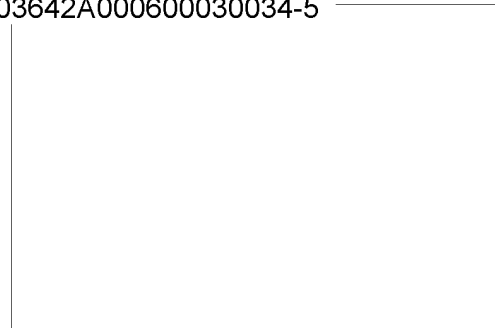
the copper block and acted as a mold release. After the plastic had cooled, the aluminum foil was easily removed. This method proved to be extremely successful and deep seals were obtained.

Pending the approval of the Project Officer, the lot of three thousand clams will be reworked using the latter method of sealing.

FINANCIAL STATEMENT

Total Amount of Contract	\$ 13,445.00
Expenditures for June 1959	9.55
Total Expenditures to 30 June 1959	13,385.03
Balance of Contract	59.97

Expiration Date: 2 July 1959



File

*ED 184F Exple. Con-
tainer Clam,
MK II*

PROGRESS REPORT
FOR
MARCH 1959
ON THE
CLAM PRODUCTION
RD 45, TASK ORDER S

17 April 1959

Work was continued intermittently on assembling the Clams due to the priority of other tasks. It is expected that the contract will be complete by the middle of April, however, it is now evident that additional funds will be required due to the additional inspection required on sealing in the inserts and also to unexpected expense of replacing several of the magnet knock-out pins in the injection mold.

The apparently large expenditure for the month is due to the payment of open commitments from February.

FINANCIAL STATEMENT

Total Amount of Contract	\$ 12,614.00
Expenditures for March 1959	3,639.00
Total Expenditures to 31 March 1959	12,580.14
Balance of Contract	33.86

Expiration Date: 2 July 1959

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PROGRESS REPORT
FOR
FEBRUARY 1959
ON THE
CLAM PRODUCTION
RD 45, TASK ORDER S

25 March 1959


Following acceptance of the remaining parts, assembly of the clam was started during the last week of February.

It was found that the box had small amounts of flashing around the small holes, which is being rimmed off before assembly. The inserts are heat sealed using Silicone grease and are then water tested in order to determine that the seal is gas tight. The adapters are then installed, finally the brackets are locked in place by melting the upstanding pins. Pairs of magnets are assembled to each spring before the marks designating the north seeking poles are removed. They are then installed in the box by squeezing the magnet bracket with needle-nose pliers. To make sure the magnets are firmly attached, they are tested by placing the box on a steel plate, the former is then pulled upwards. Some failures have been noted in this test due to defective molded parts and these boxes were eliminated. Finally the lid is then put in place and two clams are then attached to each other and packed in slotted dividers within a cardboard shipping carton.

The assembly operation has gone very well and no serious trouble has been experienced. Assembly of the entire lot should be finished during the month of April.

FINANCIAL STATEMENT

Total Amount of Contract	\$ 12,614.00
Expenditures for February 1959	8,940.23
Total Expenditures to 28 February 1959	587.48
Balance of Contract	3,673.77
(Open Commitments - \$2,325.11)	
Expiration Date: 2 July 1959	



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PROGRESS REPORT
FOR
JANUARY 1959
ON THE
CLAM PRODUCTION
RD 45, TASK ORDER S

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24 February 1959

The entire order of spring clips was received in January, but had to be rejected because of defective dimensions and was, therefore, returned to the manufacturer. Additional samples were then submitted, inspected, and found to be acceptable.

The complete shipment of magnets was also received during the month and on inspection was found to be acceptable. The magnets were then trans-shipped to the plastic parts manufacturer for molding.

The plastic molder inspected the molding die prior to running samples, and it was found that two knock-out pins in the magnet cavity were broken. These were repaired and sample boxes were molded. It was then decided to have the die sandblasted to give the finished unit a dull appearance during the molding operation, rather than have an extra operation after molding. At the time of writing, the die is expected back early in February following sandblasting. Samples of the magnet bracket were fitted into the new sample boxes and found to be acceptable, and delivery of this item is expected within ten days.

The complete cardboard packaging has been ordered. This consists of a cardboard box with three layers of twelve cells each, twenty four clams per layer, seventy two per box.

It is expected that the fabrication and assembly of parts will be started by the middle of February and it is hoped to have the full order completed by the beginning of the following month.

FINANCIAL STATEMENT

Total Amount of Contract	\$ 12,614.00
Expenditures for January 1959	5,878.99
Total Expenditures to 31 January 1959	8,352.75
Balance of Contract	4,261.25
(Open Commitments - \$2,230.84)	
Expiration Date: 2 July 1959	

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Containers,

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PROGRESS REPORT
FOR
DECEMBER 1958
ON THE
CLAM PRODUCTION
RD 45, TASK ORDER S

20 January 1959

During the month of December, time was devoted to the inspection of pre-production samples of the spring clip and magnets.

The first samples of the spring clip checked out satisfactorily except for two dimensions. When they were inserted into a box, they did not fit as well as the original spring clips. The print was checked against the drawing used in the original production and was found to be in error. The dimensions should have been taken while the spring was in a compressed state instead of a free state. A new drawing was made and sent to the manufacturer. New samples were received and checked out dimensionally as well as functionally. Again, a discrepancy was found in the dimensions, so new samples have been requested.

Approximately 2700 magnets were received. Inspection found that the magnets were not made according to the print. As all surfaces had not been ground; these were returned to the manufacturer who will have to make a new mold and recast them. In addition, the manufacturer will mark the north seeking pole for easier assembly into the boxes. New magnets will be sent us the third week in January.

FINANCIAL STATEMENT:

Total Amount of Contract	\$ 12,614.00
Expenditures for December 1958	135.52
Total Expenditures to 31 December 1958	2,473.76
Balance of Contract	10,140.24
(Open Commitments \$6,908.99)	
Expiration Date: 2 July 1959	

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*ED 184F file
Explosive,
Container, Clam
ink II*

PROGRESS REPORT
FOR
NOVEMBER 1958
ON THE
CLAM PRODUCTION
RD 45, TASK ORDER S

22 December 1958

During the month of November, two preproduction samples of parts were received. The magnet bracket was checked by the inspection department and found to be satisfactory. A sample of the spring clip, upon inspection, was found to be made of improper material. Preproduction samples have been ordered to assure that all items are made according to specifications.

The injection molding die was received and promptly sent to the manufacturer for fabrication of the plastic box.

A design of the packaging has been made with a revision that includes using a cardboard box, complete with fillers and separators. The cardboard box would then be placed in a nailed wood box for shipment.

FINANCIAL STATEMENT:

Total Amount of Contract	\$ 12,614.00
Expenditures for November 1958	1,188.05
Total Expenditures to 30 November 1958	2,338.24
Balance of Contract	10,275.76

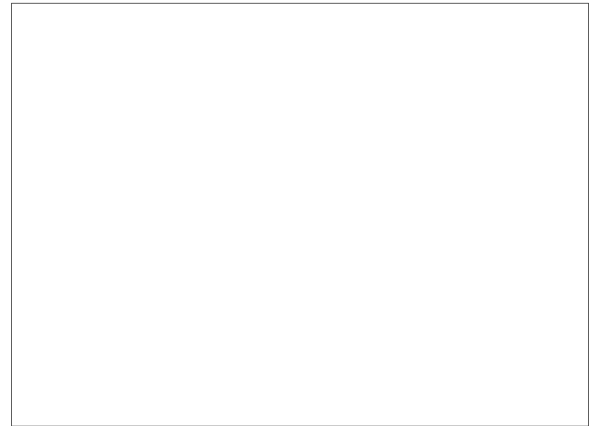
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PROGRESS REPORT
FOR
OCTOBER 1958
ON THE
CLAM PRODUCTION
RD 45, TASK ORDER S

24 November 1958

CONFIDENTIAL

During the month of October, bids for the manufacture of the parts for the Clam were received from various companies. By the latter part of the month, purchase orders were issued to the lowest bidders for the fabrication of the parts. Delivery of the parts should be completed in six weeks.

Fixtures were designed and built for the sealing of the insert into the box and for the sealing of the magnet bracket. Lubricants have been ordered to facilitate the sealing operations.

FINANCIAL STATEMENT:

Total Amount of Contract	\$ 12,614.00
Expenditures for October 1958	1,150.19
Total Expenditures to 31 October 1958	1,150.19
Balance of Contract	11,463.81

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Expiration Date: 2 July 1959

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